

Work Order ID 60619

Thursday, July 15, 2010 10:27:14 AM



Page 1

Item ID: D350-591-214

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop



Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3078	A								
DSI 9472	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

8/10/06/05

J for BG 10/08/05

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Debur

110-07-25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



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Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/26

(72)

130

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod M112860
3-Grind End Plate flush M114342

2 10.07.26

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(2) 10.07.26

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

8.0(07)26

2
26

QC

Memo

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

10.07.26

2

HandFinish

Memo

Hand Finishing

170

QC3- Inspect Part Finish

0.00

10.07.27

2

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 7/15/2010 Start Qty: 2.00

Required Date: 7/15/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Large Fab	0.00				2	0		
Large Fab	Memo	0.00							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078.								
	2-Bevel Aft end for welding								
	3-Inspect for foreign object as per QSI 024								
	4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod <i>1112860</i>								
	5-Grind End Plate flush								
210	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	0		
QC	Memo	0.00							
Quality Control									<i>BE10/08/03</i>

10-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

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Page 5

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Start Date: 7/15/2010 Start Qty: 2.00

Required Date: 7/15/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

S10100103

+2
RH

Quality Control

230

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

2 BK 10-8-11

Hand Finishing

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

START TIME: 9:05
OVEN TEMPERATURE: 320°
FINISH TIME: 9:35

2 BK 10-8-4

Powder Coating

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 14115028

Memo

0.00

⇒ 10/08/05

VZRH

260



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10/8/05 (2)

270



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

10/8/05 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, July 15, 2010 10:27:14 AM

Page 7

Item ID: D350-591-214

Accept

Revision ID:

Item Name: Heli-Access-Step, Short RH

Start Date: 7/15/2010 Start Qty: 2.00

Required Date: 7/15/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC4- 100% Inspect kits for completeness

0.00

S10606105

QC

Memo

0.00

Quality Control

290

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-214

Location: 80

PPP Rev: E

300

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

72
R11

10/8/05 sl (20)

10/08/05 AJ

MF

10-8-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 15, 2010 10:27:18 AM

Page 1

Work Order ID: 60619

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 7/15/2010

Required Date: 7/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

IPP Rev: C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

[illegible]

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, July 15, 2010 10:27:18 AM

Page 2

Work Order ID: 60619

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 7/15/2010

Required Date: 7/15/2010

Start Qty: 2.00

Required Qty: 2.00

D3066-1 Manufactured No

200 Each

163.0000 2 4



Spacer



10.07.37

Location

Loc Qty

Loc Code

WA

163

58540

77

60194

86

MS20600-AD4W4

Purchased No

200 Each

799.0000 16 32



Rivets



10.07.37

Location

Loc Qty

Loc Code

ST321

799

113368

62

114181

11

114718

2

114935

724

D3065-041

Manufactured No

200 Each

44.0000 1 2



Step Leg Assembly Hi



10.07.37

Location

Loc Qty

Loc Code

WA

44

58536

4

59678

40

D3067-1

Manufactured No

200 Each

43.0000 1 2



End Plate



10.07.27

Location

Loc Qty

Loc Code

WA

43

57926

3

59596

40

360141

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 60619

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 7/15/2010

Required Date: 7/15/2010

Start Qty: 2.00

Required Qty: 2.00

AN4-16A Purchased No 270 Each 155.0000



Bolt

Location

Loc Qty

Loc Code

ST358 155
114523 55
115016 50
115159 50

342.2070



114523 7x
115016 1x

D2732 Manufactured No 270 f



Rubber Extrusion

Location

Loc Qty

Loc Code

ST412 342.207
56516 342.207

197.0000



56516

Cut 3.00" long, qty 4

AN3-35A



Bolt

Purchased No 270 Each

Location

Loc Qty

Loc Code

ST353 197
115016 97
115108 100

273.0000



115016

AN4-11A



Bolt

Purchased No 270 Each

Location

Loc Qty

Loc Code

ST357 273
110382 273

0.0000



110382

AN960D416

NAS1149D0463J



Washer

Purchased No 270 Each

24

115000

Thursday, July 15, 2010 10:27:18 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 60619

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

D2230-3 Manufactured No 270 Each



Lug

Location	Loc Qty
ST476	115
55452	2
59115	1
59418	112

D2856-400 Manufactured No 270 f



Abraison Strip

Location	Loc Qty
ST403	160.9388421
56626	160.938842

cut 7.20" long, qty 1

MS21042L3



Nut

Purchased No 270 Each

Location	Loc Qty
ST300	2684
112385	4
114523	204
114718	476
114784	2000

Start Date: 7/15/2010

Required Date: 7/15/2010

Start Qty: 2.00

Required Qty: 2.00

115.0000

2

4

Loc Code

160.9388

0.6

1.2

Loc Code

2,684.000

1.2

4

Loc Code

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Shop Packet Print

Page 4

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 7/15/2010

Required Date: 7/15/2010

Start Qty: 2.00

Required Qty: 2.00

AN4-13A Purchased No 270 Each 806.0000



Bolt

Location	Loc Qty	Loc Code
ST351	4	
109282	4	
ST357	302	
114941	252	
115108	50	
ST358	500	
115159	500	

D2230-1 Manufactured No 270 Each 5.0000



Lug

Location	Loc Qty	Loc Code
ST476	5	
59909	5	

MS21042L4 Purchased No 270 Each 4,191.000



Nut

Location	Loc Qty	Loc Code
ST300	4191	
113422	68	
114523	28	
114718	95	
114784	2000	
115108	2000	

AN960J10 NAS1149D0363J Purchased No 270 Each 0.0000



Washer

Thursday, July 15, 2010 10:27:18 AM

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Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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RELEASED
02.01.20

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60419*
10-7-15

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

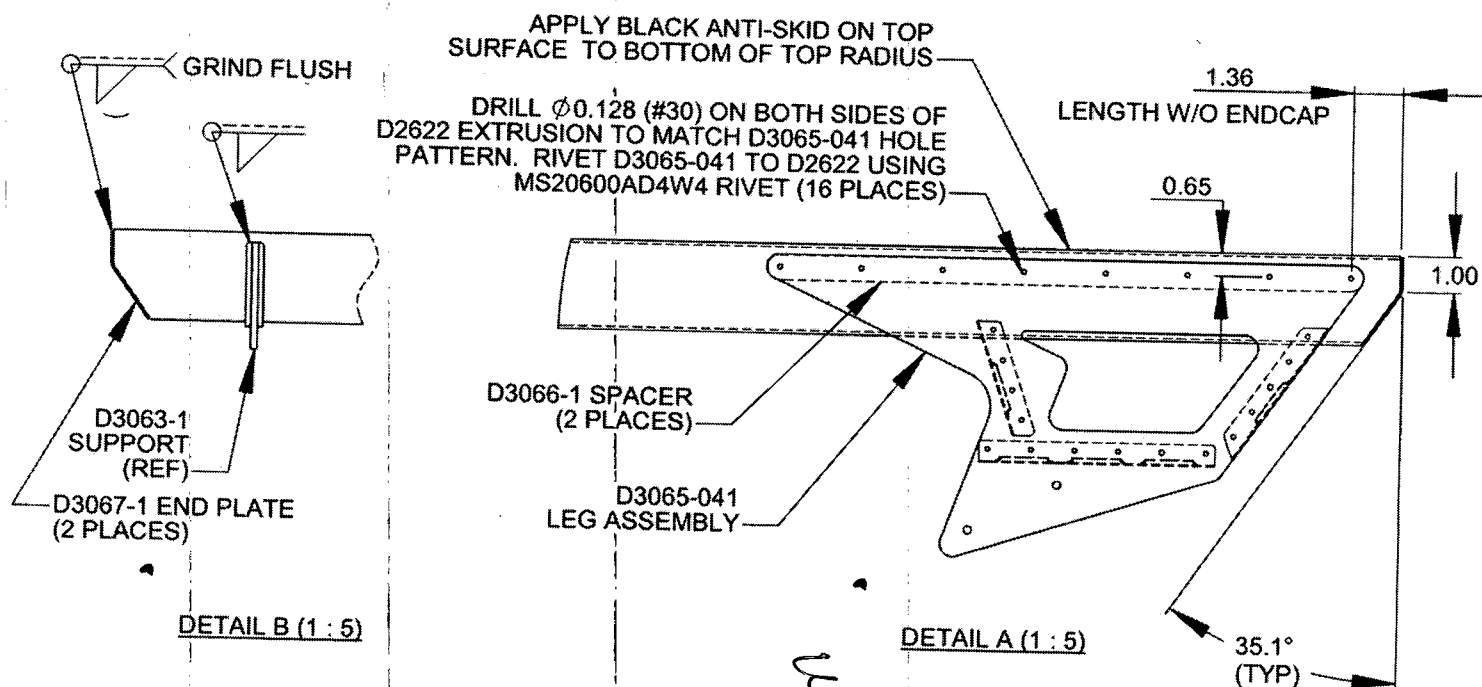
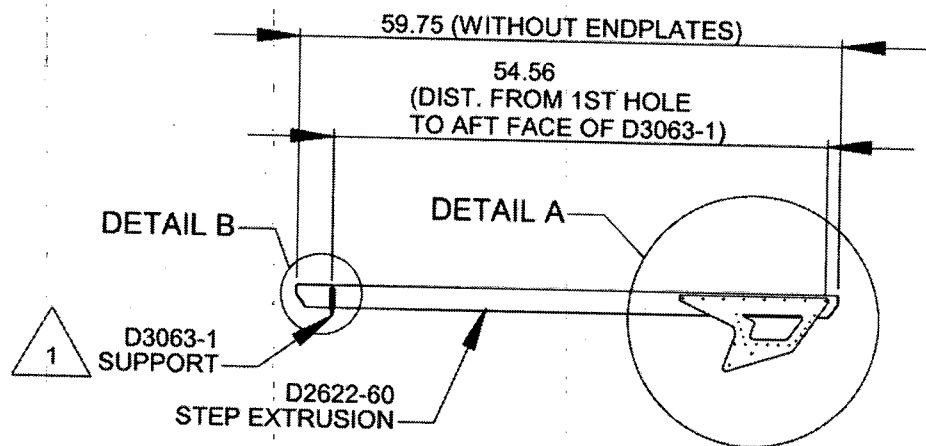
NOTE: Date & initial all entries



59.6
- 1.36
58.39

RELEASED
02.09.2011

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
02.09.11	STEP ASSEMBLY, HI SHORT	SHEET 2 OF 2
		SCALE 1:20



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NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
4	4						1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
		2	2	2	2			D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
8	8					4	4	D2230-3	MOUNTING LUG
								D2274	RADIUS BLOCK
4	4	4	4	4	4	2	2	D2618	BUSHING
2	2	1	1	1	1			D2732-030	CUSHION
2	2					2	2	D2856-400-720	ABRASION STRIP
1	1							D3064-1	CLAMP
4	4							D3079-041	SUPPORT ASSEMBLY
								D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2			AN3-35A	BOLT
10	10	2	2	2	2	2	2	AN4-11A	BOLT
		4	4	4	4			AN4-13A	BOLT
						8	8	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

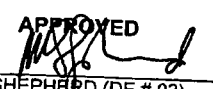
For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
	X			D350-591-214	Heli-Access-Step™, Short Step - High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step - Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE		RF	09.08.05
REV.	DESCRIPTION		BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9472 TITLE BOLT ADDITION DATE 09.08.05 COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
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CHECKED	LP			
MFG. APPR.	NDA			
APPROVED	AM			
DE APPR.	MF	REV. A SHEET 1 OF 2 SCALE NTS		